

SHIP Friday

Page 1

Work Order ID 57813

Thursday, April 15, 2010 3:57:55 PM



Item ID: D119-696-011

Accept



Setup

Start



Revision ID:

Item Name: Single Cargo Mirror Installation

Stop



Start Date: 4/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-4-16

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

CHG004

S 10/04/16

HJ for BG 10/04/16

110



Packaging

Packaging

Packaging

Memo

0.00

S 10/04/16

P 10/4/16

(1)

120



QC4- 100% Inspect kits for completeness

0.00

QC

Quality Control

Memo

G 10/04/16

0.00

HJ

DART		TEL.: 1-613-632-3336	
TRANSPORT CANADA APPROVAL # 09-89		FAX: 1-613-632-4443	
P/N	D119-696-011	CHG	CHG003
DESC	Single Cargo Mirror	STC	SR01043SE
LOT	B18131	STC	
MODEL	Agusta A119	STC	

MADE IN CANADA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



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Cust Item ID:

Required Date: 4/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

0.00

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-696-011

Location:

PPP Rev: *Neu E*
Ready/16 ①

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/14/16 R
MF
10-4-16

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Picklist Print

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Work Order ID: 57813



Parent Item: D119-696-011



Parent Item Name: Single Cargo Mirror Installation

Start Date: 4/15/2010

Required Date: 4/16/2010

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D119-696-041 		Manufactured	No			110	Each	4.0000	1.0000			

Single Cargo Mirror Assy

Warehouse

Location

Premier

Mezz

18131

Loc Qty

Loc Code

4

4

Manufactured No

110

Each

13.0000

1.0000

18131

D2053



Mounting Bracket

Warehouse

Location

Main Warehouse

ST005

47595

Loc Qty

Loc Code

13

13

Manufactured No

110

Each

25.0000

1.0000

47595

ID2067



Connector

Warehouse

Location

Main Warehouse

ST006

54698

Loc Qty

Loc Code

25

25

54698

4/16/10 (1)

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Parent Item: D119-696-011



Parent Item Name: Single Cargo Mirror Installation

Start Date: 4/15/2010

Required Date: 4/16/2010

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D207.1 		Manufactured	No			110	Each	10.0000	1.0000			

Cable Assembly

Warehouse

Location

Main Warehouse

ST222

Loc Qty

10

Loc Code

57578



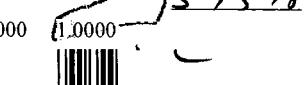
Placard

Manufactured

No

110

10.0000



Warehouse

Location

Main Warehouse

ST036

Loc Qty

10

Loc Code

AN526-1032R9



Screw

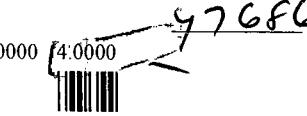
Purchased

No

47686

110

10.0000



Warehouse

Location

Main Warehouse

ST328

Loc Qty

207

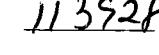
Loc Code

113928

114382

7

200



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Single Cargo Mirror Installation

Start Date: 4/15/2010

Required Date: 4/16/2010

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10-N001149-D03630		Purchased	No			110	Each	0.0000	4.0000		M114292	
--------------------------	--	-----------	----	--	--	-----	------	--------	--------	--	---------	--

Washer												
--------	--	--	--	--	--	--	--	--	--	--	--	--

MS21919-DG5		Purchased	No			110	Each	40.0000	2.0000			
-------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

Clamp												
-------	--	--	--	--	--	--	--	--	--	--	--	--

Warehouse
Location

Main Warehouse

ST306 40

114348 40

110 Each 479.0000 4.0000

Loc Qty

Loc Code

M114348

S	MS27039-1-09	Purchased	No									
---	--------------	-----------	----	--	--	--	--	--	--	--	--	--

Warehouse
Location

Main Warehouse

ST291 479

111650 444

18057 35

Loc Qty

Loc Code

M111650

W/O:		WORK ORDER CHANGES					
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Parent Item: D119-696-011



Parent Item Name: Single Cargo Mirror Installation

Start Date: 4/15/2010

Required Date: 4/16/2010

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS35489-9 		Purchased	No			110	Each	96.0000	1.0000			

Grommet

Warehouse

Location

Main Warehouse

ST296	96
107376	16
109371	80

107376

ALS-1032-130

AELES-1032-130



INSERT

Purchased

No

110

Each

0.0000

2.0000



m113238

Re 10/4/16 0

W/O:		WORK ORDER CHANGES					
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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S

25.2 CARGO MIRROR REMOVAL

1. Loosen MS21042-3 nut and remove D2071 control cable from D2067 connector.
2. Remove (4) MS27039-1-09 screws and remove D3072-1/-2 brackets. Re-install MS27039-1-08 screws.
3. Remove (2) AN526-1032R9 screws and (2) MS21919DG5 clamps.
4. Remove (2) AN526-1032R9 screws, the D2053 bracket and the D2071 cable assembly. Re-install AN526-1032R9 screws to plug inserts.
5. Seal MS35489-9 grommet hole with PRC / RTV / Proseal 890 / Sikaflex-241 / Sikaflex-291 / MIL-C-8802 Class B2 sealant.

25.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-696-011 Cargo Mirror Installation	2.2 lb 1.00 kg	7.0 in 0.28 m	15.4 in-lb 0.28 m-kg	22.0 in 0.87 m	48.4 in-lb 0.87 m-kg
D119-696-013 Cargo Mirror Installation	3.0 lb 1.36 kg	1.0 in 0.04 m	3.0 in-lb 0.05 m-kg	22.0 in 0.87 m	66.0 in-lb 1.18 m-kg

25.4 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Part Number	Description
X				D119-696-011	SINGLE CARGO MIRROR INSTALLATION
	X			D119-696-013	DUAL CARGO MIRROR INSTALLATION
1		X		D119-696-041	SINGLE CARGO MIRROR ASSEMBLY
	1		X	D119-696-043	DUAL CARGO MIRROR ASSEMBLY
		1	2	D2011-101	MIRROR ASSEMBLY
		L	1	D2053	BRACKET
			2	D2054	BUSHING
			2	D2055	CLAMP
		1	1	D2056	BELL CRANK
			1	D2057	PLUG
			1	D2067	CONNECTOR
		L	1	D2071	CABLE ASSEMBLY
			1	2	*D3014-1
			1	1	LOCKNUT
			1	1	BRACKET
			1	1	BRACKET
			1	D3074-1	ARM
			1	D3074-3	ARM
			1	D3083-1	PLACARD
	4	4	1	AN526-1032R9	SCREW
	4	4	6	AN960JD10	WASHER
			1	2	*AN960JD416L
			3	3	WASHER
			3	MS21042L3	NUT (or MS21042-3)
	2	2		MS21919DG5	CLAMP
	4	4		MS27039-1-09	SCREW
			3	3	MS27039-1-18
	2	2		MS35489-9	SCREW
				AKS7-1032-130	GROMMET
				AKS7-1032-130	INSERT (or ALS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or AEIS-032-130)

*INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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25-00-00

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